

Work Order ID 56531

March 1, 2010 9:31:13 AM



Page 1

Item ID: D3538-1

Accept



Setup Start



Revision ID:

Item Name: Hinge Bracket

Stop



Start Date: 3/01/10

Start Qty: 12.00



Cust Item ID:

Required Date: 3/08/10

Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3538	Rev A
-------	-------

100	0.00
-----	------



BAND SAW

Bandsaw

Memo

Jeaspa Bandsaw

Cut blanks 1.500" long

110	0.00
-----	------



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Machine as per Folio FA651 and Dwg D3538LJ2-Deburr

DJP
10/03/03

12 Ø

120	0.00
-----	------



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

MW=
10/03/04

12 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56531

March 1, 2010 9:31:14 AM



Page 2

Item ID: D3538-1

Accept



Setup Start



Revision ID:

Item Name: Hinge Bracket

Stop



Start Date: 3/01/10 Start Qty: 12.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

QC8- Inspect parts - second check

0.00

SA 10/04/04

12 6

Quality Control

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

W 10/03/05

(X12) 8

Hand Finishing

Memo

0.00

150



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

A1113/70

Powder Coating

Memo

0.00

START TIME: 10:00AM OVEN TEMPERATURE:
10:30AM FINISH TIME: 370° F

→ W 10/03/10 (X13) 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56531



March 1, 2010 9:31:14 AM

Page 3

Item ID: D3538-1

Accept



Setup

Start



Revision ID:

Item Name: Hinge Bracket

Stop



Start Date: 3/01/10 Start Qty: 12.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Draw
Number

BR 103-10

Draw
Rev.

Plan
Code

Accept
Qty

12

Reject
Qty

0

Reject
Number

Insp.
Stamp

170



Packaging

Packaging

Identify as per dwg & Stock Location: 69

0.00

10/03/10 12

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/11 JJ

MF 10-3-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 1, 2010 9:31:13 AM

Page 1

Work Order ID: 56531



Parent Item: D3538-1



Parent Item Name: Hinge Bracket

Start Date: 3/01/10

Required Date: 3/08/10

Comments: IPP Rev:A New Issue 06-10.03 EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased		No		100	f	48.8800	2.4000			

6061-T6 Bar 1.25 x 1.25



Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	48.88
106259	14
109058	21.43
110001	13.45

2.4 DTP 10/03/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Hinge Bracket		Part Number:	D3538-1
Inspection Dwg: D3538 Rev: A			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

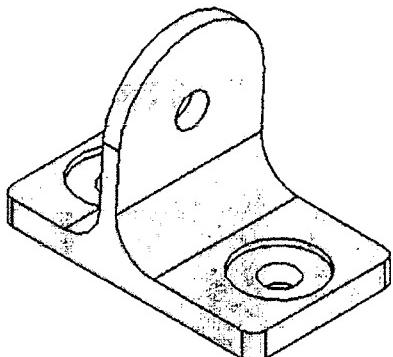
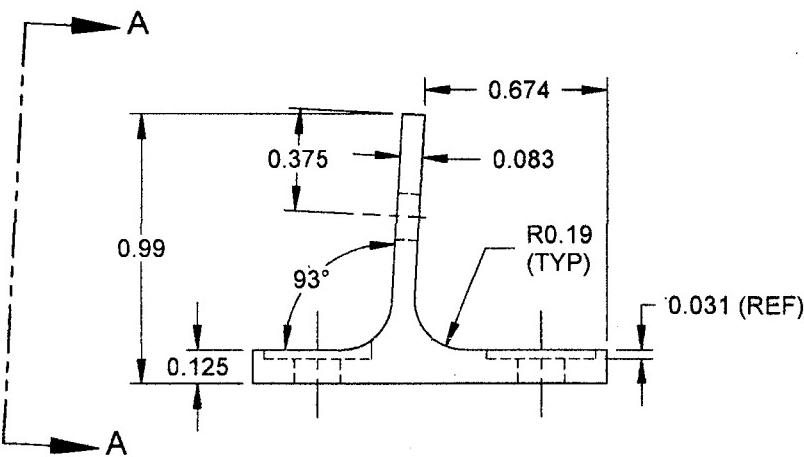
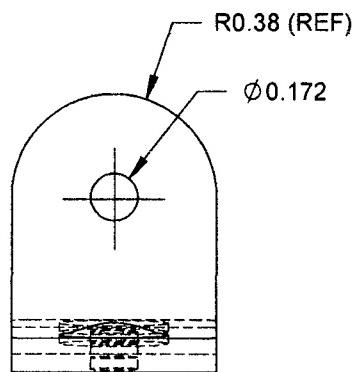
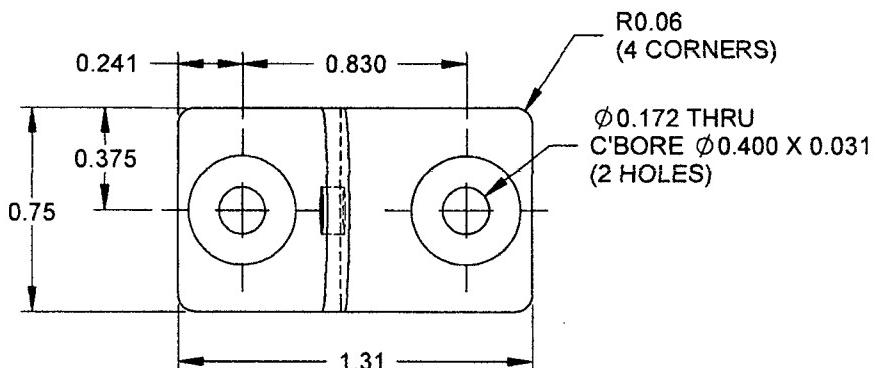
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.751	✓			
0.375	+/-0.010	.375	✓			
0.241	+/-0.010	.241	✓			
0.830	+/-0.010	.828	✓			
Ø0.172	+0.005/-0.001	Ø.175	✓			
Ø0.400	+0.006/-0.001	Ø.400	✓			
0.031	+/-0.010	.029	✓			
1.31	+/-0.030	1.31	✓			
0.375	+/-0.010	.374	✓			
0.99	+/-0.030	.992	✓			
0.125	+/-0.010	.126	✓			
R0.19	+/-0.030	R.19	✓			
0.083	+/-0.010	.084	✓			
93°	+/-0.5°	93°	✓			
0.674	+/-0.010	.674	✓			
R0.38	+/-0.030	R.38	✓			
Ø0.172	+0.005/-0.001	Ø.175	✓			

Measured by:	MW	Audited by:	SA	Prototype Approval:	N/A
Date:	10/03/04	Date:	10/05/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	JL

DART

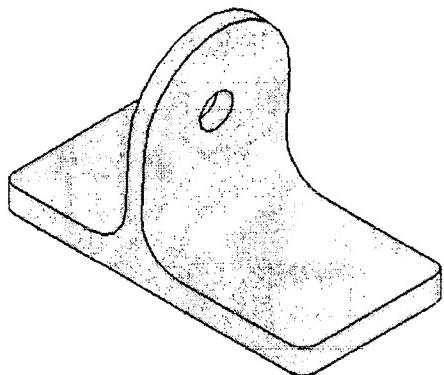
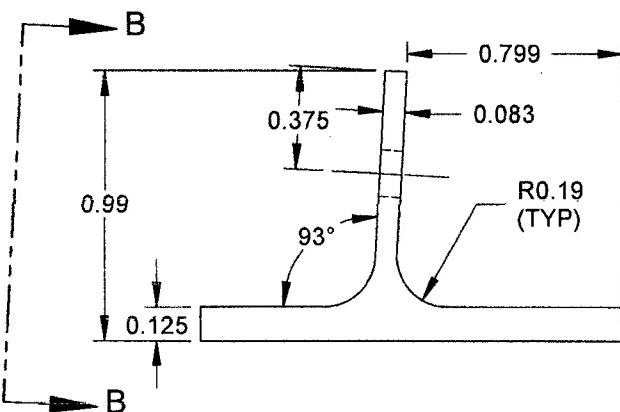
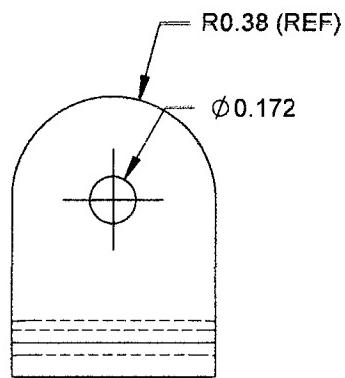
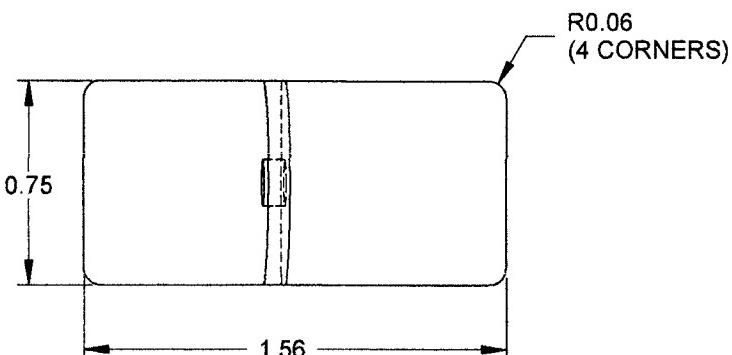
DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3538	REV. A	SHEET 1 OF 2
DATE 06.10.13		TITLE HINGE BRACKET	SCALE 1:1	
REV A	DATE 06.10.13	DESCRIPTION NEW ISSUE		

**RELEASED**
(06.10.13) *[Signature]***AUXILIARY VIEW A****D3538-1 HINGE BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

DART

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3538	REV. A SHEET 2 OF 2
DATE 06.10.13	TITLE HINGE BRACKET	SCALE 1:1	

**RELEASED**
06.10.13 *[Signature]***AUXILIARY VIEW B****D3538-3 HINGE BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

COPYRIGHT © 2006 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.